



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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Deviation
RBW895-3101-04-117-01

Job Sheet 199607



Part No: RBW895-3101-04-117-01

Job Qty: 2 pcs *4 pcs 2ml*

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/14/19

Description:

Type: SOLD

Note: DWG RBW895-3101-04-117 Rev 1 IPP Rev. A 19.08.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	NV5000 - 1	2 pcs	10/14/19	10/14/19	1.00	4.00	NV5000 - 1	ALA/ML
							NV5000 - 2	
110	QC 2	2 pcs	10/14/19	10/14/19	0.00	0.00	QC 2 - 1	ALA/ML
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

ART
OSPACE

Order No: S218241

W895-3101-04-117-01
99607
/Batch: S218241

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K0A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/30/19

19-09-28

19-09-28



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Container No: S218241



Part: RBW895-3101-04-117-01

Job No: 199607

Serial No/Batch: S218241

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 09/30/19

Plex 8/28/19 11:24 AM Dart.lajeunesse.marie

120 QC 8	2 pcs	10/14/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	A- 19-0-01
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Powdercoat - 13 Yellow - B4B 2 pcs <i>M 138677</i>	2 pcs	10/14/19	0.00 0.20	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BK 19-10-2
				Powdercoat - 4 - B4B	
140 QC 3 <i>START: 2:35 OUT: 3:00 FINISH: 3:15</i>	2 pcs	10/14/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
150 Packaging 3-1 - Stock - B4B 2 pcs	2 pcs	10/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DA
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
160 QC 21 - SA	2 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 100 - 1-Machine as per folio FC <u>962</u> FOLIO REV: <u>AA</u> DWG REV: <u>1</u> 2-Deburr Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - (Powdercoat13 - Yellow #13538) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ Mask holes. 140 - QC3- Inspect Part Finish Standard Process 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B2.500X3.000	6061T6 Bar 2.500-X3.000	1.9400 ft (.97 ea)	100-NV5000 - 1	524489 1x	
	2.500 x 3.000			5203254 2x	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-NV5000 - 1	M6061T6B2.500X3.000	2	0	0	
Part Specifications					
Specifications could not be found.					

6A062F

DART AEROSPACE LTD		Work Order:	199607
Description: FRAME		Part Number:	RBW895-3101-04-117-01
Inspection Dwg: RBW895-3101-04-117		Rev: 1	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.417	$\pm .005$	11.417			H-G	3/006
5.709	$\pm .005$	5.707			VERN.	MGP-04
2.362	$\pm .005$	2.362			"	"
0.195	$\pm .005$	.193			GP	—
V.42 x 82°	$\pm .010$	.425			VERN.	MGP-04
.756	$\pm .005$	.755			"	"
9.126	$\pm .005$	9.125			H-G	3/006
2.380	$\pm .005$	2.378			VERN.	MGP-04
2.888	$\pm .005$	2.888			"	"
1.181	$\pm .005$	1.181			"	"
R.12	$\pm .010$	R.125			R-G	—
4.921	$\pm .005$	4.921			VERN.	MGP-04
.811	$\pm .005$	.811			H-G	3/006
M10 x 1.5mm	60 NO-90	60			T-G	HT-272
Ø1.024	$\pm .005$	1.023			VERN.	MGP-04
.04 x 45°	$\pm .000$	.04			"	"
1.968	$\pm .005$	1.970			"	"
2.159	$\pm .005$	2.158			D-M	MGP-05
.600	$\pm .005$	.598			VERN	MGP-04
.215	$\pm .005$	.218				
R.13	$\pm .010$	R.13			R-G	—

Measured by: ALA. / <i>[Signature]</i>	Checked by: B. <i>[Signature]</i>	QC Inspector:
Date: 19-09-28	Date: 19-10-01	Date:

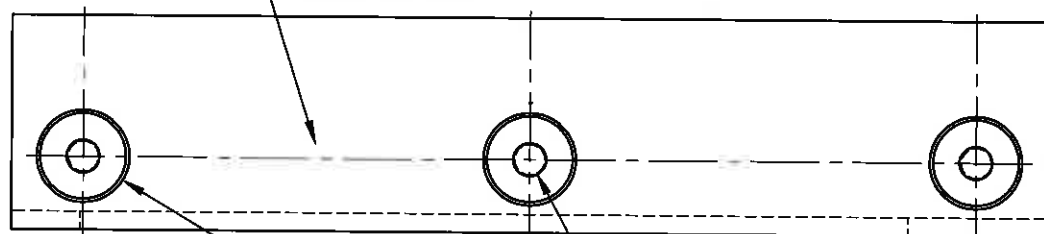
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-01 CH'D DIMS WAS 3X R.118 IS 3X .12, WAS 2X R.138 IS 2X R.13, WAS 3X Ø.394 THRU C-SINK Ø.394 X 100° IS 3X Ø.205 THRU ✓Ø.42 X 90°. CH'D NOTE WAS MACHINE ENGRAVE TOOL No., IN 3/16 LETTERS; SERIAL No., & "MADE IN USA", TO FIT. IS MACHINE ENGRAVE T/N, S/N, "MADE IN USA".	2/14/14	DPD	GE

MACHINE ENGRAVE T/N, S/N,
"MADE IN USA"



3X Ø1.024
.04x45°

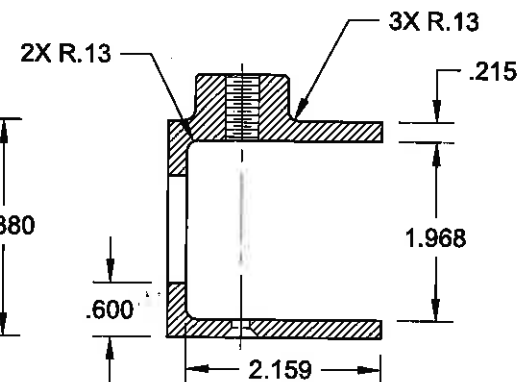
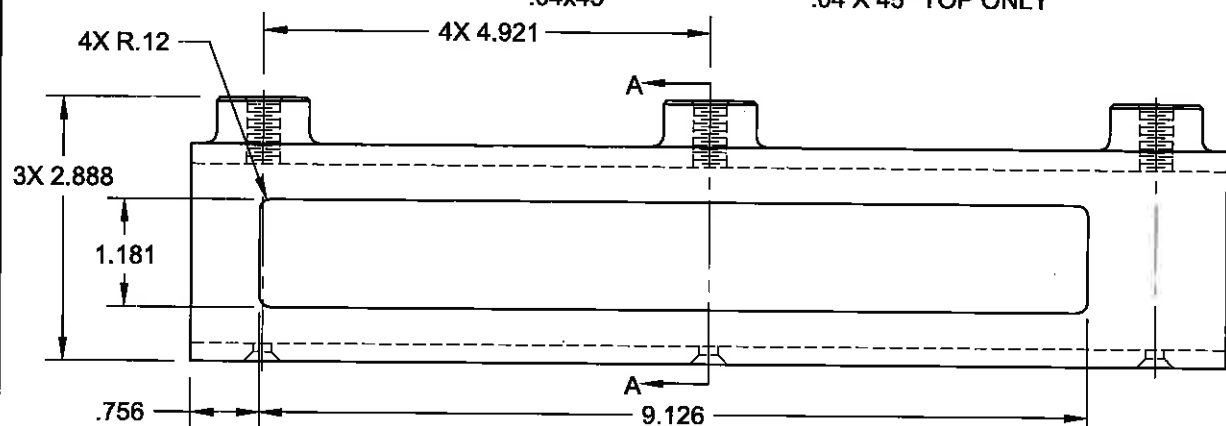
3X M10 X 1.5
.04 X 45° TOP ONLY

6X .811

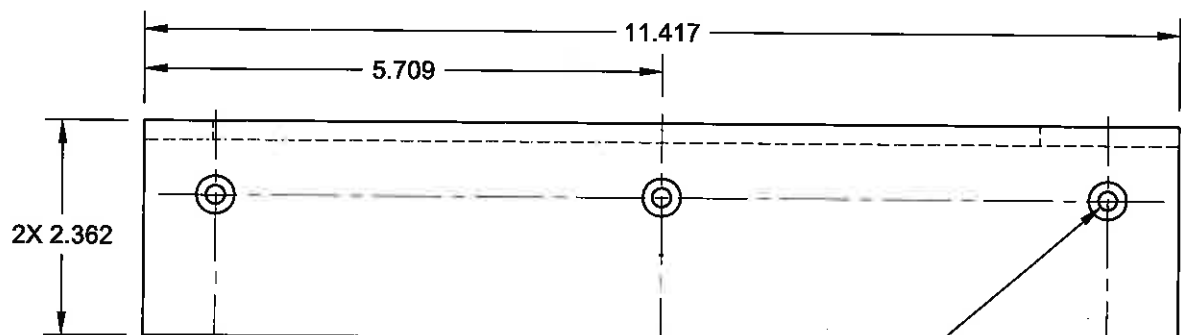
(-01)
FRAME

SHOP COPY
REF.
ENGINEER
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK

195607
MLJ
19-08-20



SECTION A-A



3X Ø.205 THRU
✓ .42 X 90°

RED BARN MACHINE	
TITLE M/R BLADE BLOCKING AND PROTECTOR TOOL	
DWG NO. RBW895-3101-04-117-01	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL UNITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED: <i>D. Wed</i> HEAT TREAT: POWDER COAT FORREST FINISH: T5820 SS YELLOW RIBBON SPEC: MIL-P-88348 USED ON MODEL: AW109, AW119	
SCALE 1:2	DATE 3-4-10
SHEET 3 of 9	

Entered: JK Date: Oct 23/19



NCR No. 19-7506 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>199607</u> Part No. <u>RBW895-3101-04</u> <u>-117-01</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐					
Date: <u>Sept. 17, 2019</u>		Sequence #: <u>100</u>		QTY Affected: <u>2</u> <u>4</u>		MRB (QSI042) DAS 51 9-89 19/09/17			
Description Work Order Deviation DIM WAS $\phi .205$ THRU $\vee .42 \times 90^\circ$ IS $\phi 0.194$ THRU $\vee \phi 0.42 \times 82.0^\circ$				Disposition THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED				Completed By <u>ALA</u> 19/09/30 Lead hand / Supervisor <u>JK</u> 19/09/30 QC / QA Coordinator <u>68</u> 9-89 OCT 02 2019	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							